

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 28053A		
Estimate Number	: 11702		
P.O. Number	: N/A	Part Number	: D2724041
This Issue	: 8/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2724 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26879A	Drawing Revision	: C
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 8/31/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	3
Comment	: Est Rev: E As Per Ecn 766 06-01-06 JLM	Um:	Each

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion
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327077

Check Material for any Dents or Defects

PE.06.08.16

3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

NE. 06.08.16

pg. 06 - 08 - 16

3

65

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2 D2734 End Cap

34581

327281

04.06.08.17

—

40 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2 D3458-1 Plate

Batch
327128

86-08-15

(1)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:26:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, LH

Job Number: 28053A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

~~334~~ 27253

P.E. 06.08.17 3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M100660

P.E. 06.08.22 3

Grind end cap welds flush

P.E. 06.08.22 3

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

J. 06.08.22 (3)

NOV 08/23 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.08.25 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P.E. 06.08.30

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

P.E. 06.08.30 3

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M15689 *MDK*

P.E. 06.08.30 3

P.E. 06.08.30 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/07
QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:26:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 28053A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Handwritten: 11/06/08/31 (3)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Handwritten: a.m 06-08-31 (3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: DC 06-08-31 (3)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: a.m 06-08-31 (3)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

Handwritten: a.m 06-08-31 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 4/9/6 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: N/A

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 06/09/07

Job Completion



Handwritten: W 06-09-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes No DQA: _____ Date: _____

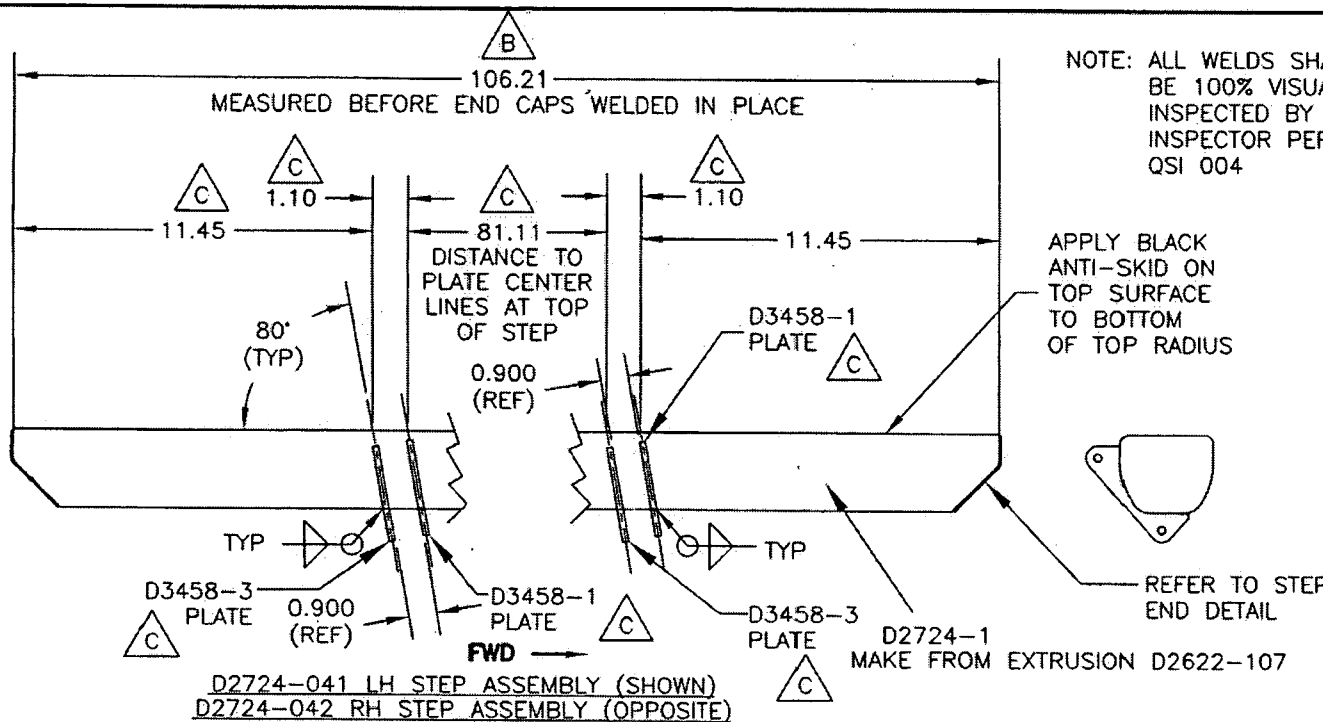
QA: N/C Closed: _____ Date: _____

DART

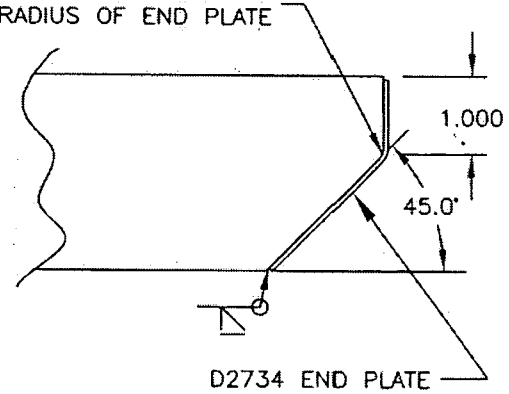
RELEASED

8.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 280537
WORK ORDER
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2724	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.09.19	206L/407 STEP ASSEMBLY	NTS	
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

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